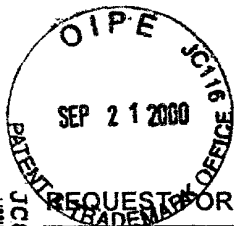


09-22-00

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PTO/SB/13/PCT (12-97)
Approved for use through 9/30/00. OMB 0651-0032
Patent and Trademark Office; U.S. DEPARTMENT OF COMMERCE
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CONTINUING APPLICATION
REQUEST FOR FILING A CONTINUATION OR DIVISION OF AN INTERNATIONAL APPLICATION

DOCKET NUMBER	ANTICIPATED CLASSIFICATION OF THIS APPLICATION		PRIOR APPLICATION EXAMINER	ART UNIT
20183	CLASS	SUBCLASS		

Address to:
Assistant Commissioner for Patents
Washington, D.C. 20231

This is a request for filing a ☒ continuing ☐ divisional application under 37 CFR 1.53(b), of pending prior international application Number PCT EP/99/01649 filed on 3/12/99 entitled A SPECIAL CHAMFERED TILE AND THE PROCEDURE FOR ITS MANUFACTURE

which designated the United States.

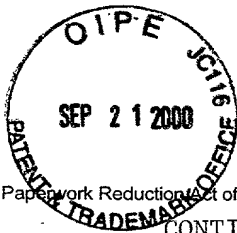
Note: 37 CFR 1.53(c) or (d) cannot be used to file a continuation or divisional application of an international application which has not entered the national stage.

CLAIMS	(1) FOR	(2) NUMBER FILED	(3) NUMBER EXTRA	(4) RATE	(5) CALCULATIONS
TOTAL CLAIMS (37 CFR 1.16(c))	8	- 20 =	0	x \$ _____ =	\$ 690
INDEPENDENT CLAIMS (37 CFR 1.16(b))	3	- 3 =	0	x \$ _____ =	
MULTIPLE DEPENDENT CLAIMS (if applicable) (37 CFR 1.16(d))				+ \$ _____ =	
	BASIC FEE (37 CFR 1.16(a))			+ _____	
	Total of above Calculations =			690	
	Reduction by 50% for filing by small entity (Note 37 CFR 1.9, 1.27, 1.28).			345	
	TOTAL =			\$345.00	

- Enclosed are the specification, claims and drawing(s).
- ☒ A statement to establish small entity status under 37 CFR 1.9 and 1.27 is enclosed.
- ☒ The Commissioner is hereby authorized to charge any fees which may be required under 37 CFR 1.16 and 1.17, or credit any overpayment to Deposit Account No. 22-0355. A duplicate copy of this sheet is enclosed.
- ☒ A check in the amount of \$ 345.00 is enclosed.
- ☒ Amend the specification by inserting before the first line the sentence: "This application is a ☒ continuing ☐ division of international application number PCT EP/99/01649, filed 3/12/99 (status, abandoned, pending, etc.)."

[Page 1 of 2]

Burden Hour Statement: This form is estimated to take 0.5 hours to complete. Time will vary depending upon the needs of individual case. Any comments on the amount of time you are required to complete this form should be sent to the Chief Information Officer, Patent and Trademark Office, Washington, DC 20231. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Assistant Commissioner for Patents, Washington, DC 20231.



Under the Paperwork Reduction Act of 1995, no persons are required to respond to a collection of information unless it displays a valid OMB control number.

PTO/SB/13/PCT (12-97)
Approved for use through 9/30/00. OMB 0651-0032
Patent and Trademark Office; U.S. DEPARTMENT OF COMMERCE

CONTINUING APPLICATION
(REQUEST FOR FILING A ~~CONTINUATION~~ DIVISION OF AN INTERNATIONAL APPLICATION, PAGE 2)

6. ☒ A declaration under 37 CFR 1.63 is enclosed.

7. ☒ Priority of foreign application number MO98A000064, filed on 3/24/98 in Italy
is claimed under 35 U.S.C. 119(a) - (d).

☐ The certified copy is enclosed.

8. ☐ A preliminary amendment is enclosed.

9. ☐ Also enclosed:

Address all future correspondence to: (May only be completed by applicant, or attorney or agent of record.)

Thomas R. Vigil
c/o Vigil & Associates

836 South Northwest Highway
Barrington, Illinois 60010

September 21, 2000
Date


Signature

Thomas R. Vigil, Reg. No. 24,542
Typed or printed name

- ☐ Inventor(s)
☐ Assignee of complete interest. Certification under 37 CFR 3.73(b) is enclosed.
☒ Attorney or agent of record
☐ Filed under 37 CFR 1.34(a)

Registration number if acting under 37 CFR 1.34(a), 24,542

FEE TRANSMITTAL		Complete if Known	
for FY 2000 <small>Patent fees are subject to annual revision. Small Entity payments must be supported by a small entity statement, otherwise large entity fees must be paid. See Forms PTO/SB/09-12. See 37 C.F.R. §§ 1.27 and 1.28.</small>		Application Number	
		Filing Date	September 21, 2000
		First Named Inventor	Paolo Orlandi
		Examiner Name	Unknown
		Group / Art Unit	Unknown
TOTAL AMOUNT OF PAYMENT (\$)		385.00	Attorney Docket No. 20183

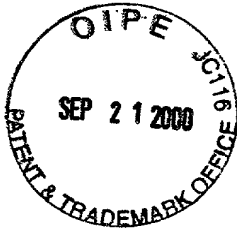
METHOD OF PAYMENT (check one)		FEE CALCULATION (continued)																																																																																																																									
1. <input type="checkbox"/> The Commissioner is hereby authorized to charge indicated fees and credit any overpayments to: Deposit Account Number _____ Deposit Account Name <u>22-0355</u> <input checked="" type="checkbox"/> Charge Any Additional Fee Required Under 37 CFR §§ 1.16 and 1.17		3. ADDITIONAL FEES <table border="1"><thead><tr><th>Large Entity Fee Code (\$)</th><th>Small Entity Fee Code (\$)</th><th>Fee Description</th><th>Fee Paid</th></tr></thead><tbody><tr><td>105 130</td><td>205 65</td><td>Surcharge - late filing fee or oath</td><td></td></tr><tr><td>127 50</td><td>227 25</td><td>Surcharge - late provisional filing fee or cover sheet</td><td></td></tr><tr><td>139 130</td><td>139 130</td><td>Non-English specification</td><td></td></tr><tr><td>147 2,520</td><td>147 2,520</td><td>For filing a request for reexamination</td><td></td></tr><tr><td>112 920*</td><td>112 920*</td><td>Requesting publication of SIR prior to Examiner action</td><td></td></tr><tr><td>113 1,840*</td><td>113 1,840*</td><td>Requesting publication of SIR after Examiner action</td><td></td></tr><tr><td>115 110</td><td>215 55</td><td>Extension for reply within first month</td><td></td></tr><tr><td>116 380</td><td>216 190</td><td>Extension for reply within second month</td><td></td></tr><tr><td>117 870</td><td>217 435</td><td>Extension for reply within third month</td><td></td></tr><tr><td>118 1,360</td><td>218 680</td><td>Extension for reply within fourth month</td><td></td></tr><tr><td>128 1,850</td><td>228 925</td><td>Extension for reply within fifth month</td><td></td></tr><tr><td>119 300</td><td>219 150</td><td>Notice of Appeal</td><td></td></tr><tr><td>120 300</td><td>220 150</td><td>Filing a brief in support of an appeal</td><td></td></tr><tr><td>121 260</td><td>221 130</td><td>Request for oral hearing</td><td></td></tr><tr><td>138 1,510</td><td>138 1,510</td><td>Petition to institute a public use proceeding</td><td></td></tr><tr><td>140 110</td><td>240 55</td><td>Petition to revive - unavoidable</td><td></td></tr><tr><td>141 1,210</td><td>241 605</td><td>Petition to revive - unintentional</td><td></td></tr><tr><td>142 1,210</td><td>242 605</td><td>Utility issue fee (or reissue)</td><td></td></tr><tr><td>143 430</td><td>243 215</td><td>Design issue fee</td><td></td></tr><tr><td>144 580</td><td>244 290</td><td>Plant issue fee</td><td></td></tr><tr><td>122 130</td><td>122 130</td><td>Petitions to the Commissioner</td><td></td></tr><tr><td>123 50</td><td>123 50</td><td>Petitions related to provisional applications</td><td></td></tr><tr><td>126 240</td><td>126 240</td><td>Submission of Information Disclosure Stmt</td><td></td></tr><tr><td>581 40</td><td>581 40</td><td>Recording each patent assignment per property (times number of properties)</td><td>40</td></tr><tr><td>146 690</td><td>246 345</td><td>Filing a submission after final rejection (37 CFR § 1.129(a))</td><td></td></tr><tr><td>149 690</td><td>249 345</td><td>For each additional invention to be examined (37 CFR § 1.129(b))</td><td></td></tr><tr><td colspan="2">Other fee (specify) _____</td><td></td><td></td></tr><tr><td colspan="2">Other fee (specify) _____</td><td></td><td></td></tr><tr><td colspan="2">SUBTOTAL (3)</td><td>(\$)</td><td>40</td></tr></tbody></table>		Large Entity Fee Code (\$)	Small Entity Fee Code (\$)	Fee Description	Fee Paid	105 130	205 65	Surcharge - late filing fee or oath		127 50	227 25	Surcharge - late provisional filing fee or cover sheet		139 130	139 130	Non-English specification		147 2,520	147 2,520	For filing a request for reexamination		112 920*	112 920*	Requesting publication of SIR prior to Examiner action		113 1,840*	113 1,840*	Requesting publication of SIR after Examiner action		115 110	215 55	Extension for reply within first month		116 380	216 190	Extension for reply within second month		117 870	217 435	Extension for reply within third month		118 1,360	218 680	Extension for reply within fourth month		128 1,850	228 925	Extension for reply within fifth month		119 300	219 150	Notice of Appeal		120 300	220 150	Filing a brief in support of an appeal		121 260	221 130	Request for oral hearing		138 1,510	138 1,510	Petition to institute a public use proceeding		140 110	240 55	Petition to revive - unavoidable		141 1,210	241 605	Petition to revive - unintentional		142 1,210	242 605	Utility issue fee (or reissue)		143 430	243 215	Design issue fee		144 580	244 290	Plant issue fee		122 130	122 130	Petitions to the Commissioner		123 50	123 50	Petitions related to provisional applications		126 240	126 240	Submission of Information Disclosure Stmt		581 40	581 40	Recording each patent assignment per property (times number of properties)	40	146 690	246 345	Filing a submission after final rejection (37 CFR § 1.129(a))		149 690	249 345	For each additional invention to be examined (37 CFR § 1.129(b))		Other fee (specify) _____				Other fee (specify) _____				SUBTOTAL (3)		(\$)	40
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SUBMITTED BY		Complete (if applicable)	
Name (Print/Type)	Thomas R. Vigil	Registration No. (Attorney/Agent)	24,542
Signature	<i>Thomas R. Vigil</i>	Telephone	(847) 382-6500
		Date	Sept. 21, 2000

WARNING:

Information on this form may become public. Credit card information should not be included on this form. Provide credit card information and authorization on PTO-2038.

Burden Hour Statement: This form is estimated to take 0.2 hours to complete. Time will vary depending upon the needs of the individual case. Any comments on the amount of time you are required to complete this form should be sent to the Chief Information Officer, Patent and Trademark Office, Washington, DC 20231. DO NOT SEND FEES OR COMPLETED FORMS TO THIS ADDRESS. SEND TO: Assistant Commissioner for Patents, Washington, DC 20231.



PATENT
USSN - New US Continuing App
Atty Docket: 20183



IN THE UNITED STATES PATENT AND TRADEMARK OFFICE

In re Application of:

Paolo Orlandi

Group Art Unit:

Unknown

For: A SPECIAL CHAMFERED TILE AND THE
PROCEDURE FOR ITS MANUFACTURE

Examiner:

Unknown

Serial No. (Unknown)

Filed: (Being Filed Herewith)

CERTIFICATE OF EXPRESS MAIL DEPOSIT

"Express Mail" Mailing Label No. EL 468138065 US

Date of Deposit: September 21, 2000

I hereby certify that this paper, or fee, is being deposited with the U.S. Postal Service "Express Mail Post Office to Addressee" service under 37 CFR §1.10 on the date indicated above and addressed to the Assistant Commissioner of Patents, Washington, D.C. 20231.

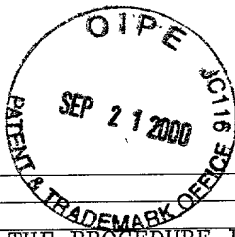
Thomas R. Vigil

(Typed or printed name of person mailing fee or paper)

(Signature of person mailing fee or paper)

The documents enclosed with and being filed with this paper are:

1. New US Continuing Application Request (2 pages)
2. 1 sheet formal drawings
3. Executed Declaration from inventor
4. 2 executed Small Entity Declarations
5. Executed Assignment & Patent Assignment Recordation Cover Sheet
6. Fee Transmittal Form
7. Check for \$345.00
8. Check for \$40.00
9. Photocopy of PCT Appl. No. PCT/EP/99 01649
10. Photocopy of IPER
11. Photocopy of Search Report
12. This Certificate of Express Mail Deposit



OMB No. 0651-0011 (12/31/86)

Applicant or Patentee: Paolo Orlandi Attorney's 20183
Serial or Patent No.: _____ Docket No.: _____
Filed or Issued: September 21, 2000
For: A SPECIAL CHAMFERED TILE AND THE PROCEDURE FOR ITS MANUFACTURE

VERIFIED STATEMENT (DECLARATION) CLAIMING SMALL ENTITY
STATUS (37 CFR 1.9 (f) and 1.27 (b)) INDEPENDENT INVENTOR

As a below named inventor, I hereby declare that I qualify as an independent inventor as defined in 37 CFR 1.9 (c) for purposes of paying reduced fees under Section 41 (a) and (b) of Title 35, United States Code, to the Patent and Trademark Office with regard to the invention entitled:
A SPECIAL CHAMFERED TILE AND THE PROCEDURE FOR ITS MANUFACTURE

- ☒ the specification filed herewith
☐ application serial no. _____, filed _____
☐ patent no. _____, issued _____

I have not assigned, granted, conveyed or licensed and am under no obligation under contract or law to assign, grant, convey or license, any rights in the invention to any person who could not be classified as an independent inventor under 37 CFR 1.9 (c) if that person had made the invention, or to any concern which would not qualify as a small business concern under 37 CFR 1.9 (d) or a nonprofit organization under 37 CFR 1.9 (e).

Each person, concern or organization to which I have assigned, granted, conveyed, or licensed or am under an obligation under contract or law to assign, grant, convey, or license any rights in the invention is listed below:

- ☐ no such person, concern or organization
☒ persons, concerns or organizations listed below*

*NOTE: Separate verified statements are required from each named person, concern or organization having rights to the invention averring to their status as small entities. (37 CFR 1.27).

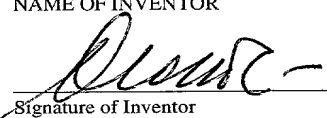
FULL NAME _____
ADDRESS _____
☐ INDIVIDUAL ☐ SMALL BUSINESS CONCERN ☐ NONPROFIT ORGANIZATION

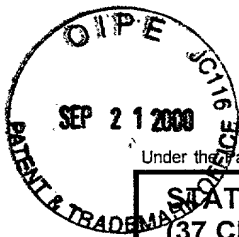
FULL NAME Casa Tile S.R.L.
ADDRESS Via Montepizzicano Interno, 73/6, 41028 Serramazzoni (Modena) Italy
☐ INDIVIDUAL ☒ SMALL BUSINESS CONCERN ☐ NONPROFIT ORGANIZATION

FULL NAME _____
ADDRESS _____
☐ INDIVIDUAL ☐ SMALL BUSINESS CONCERN ☐ NONPROFIT ORGANIZATION

I acknowledge the duty to file, in this application or patent, notification of any change in status resulting in loss of entitlement to small entity status prior to paying, or at the time of paying, the earliest of the issue fee or any maintenance fee due after the date on which status as a small entity is no longer appropriate. (37 CFR 1.28 (b)).

I hereby declare that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine or imprisonment, or both, under section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application, any patent issuing thereon, or any patent to which this verified statement is directed.

Paolo Orlandi
NAME OF INVENTOR NAME OF INVENTOR NAME OF INVENTOR

Signature of Inventor Signature of Inventor Signature of Inventor
9/14/2000
Date Date Date



STATEMENT CLAIMING SMALL ENTITY STATUS
(37 CFR 1.9(f) & 1.27(c))--SMALL BUSINESS CONCERN

Docket Number (Optional)
20183

Applicant, Patentee, or Identifier: Paolo Orlandi
Application or Patent No.: _____
Filed or Issued: September 21, 2000
Title: A SPECIAL CHAMFERED TILE AND THE PROCEDURE FOR ITS MANUFACTURE

I hereby state that I am

- ☐ the owner of the small business concern identified below:
☒ an official of the small business concern empowered to act on behalf of the concern identified below:

NAME OF SMALL BUSINESS CONCERN Casa Tile S.R.L.

ADDRESS OF SMALL BUSINESS CONCERN Via Montepizzicano Interno, 73/6
41028 Serramazzoni (Modena), Italy

I hereby state that the above identified small business concern qualifies as a small business concern as defined in 13 CFR Part 121 for purposes of paying reduced fees to the United States Patent and Trademark Office, in that the number of employees of the concern, including those of its affiliates, does not exceed 500 persons. For purposes of this statement, (1) the number of employees of the business concern is the average over the previous fiscal year of the concern of the persons employed on a full-time, part-time, or temporary basis during each of the pay periods of the fiscal year, and (2) concerns are affiliates of each other when either, directly or indirectly, one concern controls or has the power to control the other, or a third party or parties controls or has the power to control both.

I hereby state that rights under contract or law have been conveyed to and remain with the small business concern identified above with regard to the invention described in:

- ☒ the specification filed herewith with title as listed above.
☐ the application identified above.
☐ the patent identified above.

If the rights held by the above identified small business concern are not exclusive, each individual, concern, or organization having rights in the invention must file separate statements as to their status as small entities, and no rights to the invention are held by any person, other than the inventor, who would not qualify as an independent inventor under 37 CFR 1.9(c) if that person made the invention, or by any concern which would not qualify as a small business concern under 37 CFR 1.9(d), or a nonprofit organization under 37 CFR 1.9(e).

- Each person, concern, or organization having any rights in the invention is listed below:
☒ no such person, concern, or organization exists.
☐ each such person, concern, or organization is listed below.

Separate statements are required from each named person, concern or organization having rights to the invention stating their status as small entities. (37 CFR 1.27)

I acknowledge the duty to file, in this application or patent, notification of any change in status resulting in loss of entitlement to small entity status prior to paying, or at the time of paying, the earliest of the issue fee or any maintenance fee due after the date on which status as a small entity is no longer appropriate. (37 CFR 1.28(b))

NAME OF PERSON SIGNING Paolo Orlandi

TITLE OF PERSON IF OTHER THAN OWNER _____

ADDRESS OF PERSON SIGNING _____

SIGNATURE *Paolo Orlandi* DATE 9/14/2000

Application for Letters Patent
of the UNITED STATES OF AMERICA by -

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Being a citizen of -
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For:

A SPECIAL CHAMFERED TILE AND THE PROCEDURE
FOR ITS MANUFACTURE

CROSS-REFERENCE TO RELATED APPLICATIONS

This application is a Continuing Application of PCT Application No. PCT/EP 99/01649 filed March 12, 1999 which claims priority from Italian Application No. MO 98 A 000064 filed March 24, 1998

Description**A special chamfered tile and the procedure for its manufacture****Technical Field**

5 The present invention relates to a special chamfered tile and the procedure for its manufacture.

10 The manufacture of stoneware and ceramic floor and wall tiles is normally carried out by highly automated systems which are capable of producing large numbers of tiles of the same type. Since a change in format, design and/or decoration of the tiles being produced involves stopping the system and modifying parts of the equipment, the production line is generally avoided for trim pieces like, for example, the rectangular tiles used when laying frames and skirting which match the floor or wall tiles.

Background Art

15 It is known that the aforementioned articles are manufactured by means of the mechanical cutting and working of standard wall and floor tiles. For example, the standard tiles of a square type are cut to form rectangular or chamfered trim pieces or those which have at least one rounded edge to form the so-called "bird's beak" which, once the piece is laid, constitutes the visible edge of a frame or skirting which matches the floor or wall made of standard tiles.

20 Naturally, the mechanical working of the standard tiles to produce trim pieces, i.e. the cutting and the subsequent bevelling or rounding, exposes, in the area worked on, the substratum of the tile itself, which could be single fired, porcelain stoneware, double fired, porous single fired, or manufactured using other commonly known materials from the sector. Given that aesthetic appearance is an important aspect of this specific sector it therefore appears necessary to treat the area to be worked on to provide it with the finishing features which are comparable to those of the standard tiles from which they originate. The commonly known treatments envisage the glazing of the area worked on with ceramic glazes and the subsequent firing of the trim pieces according to the methods adopted for the manufacturing of the basic standard tiles.

25 However, the said commonly known procedure has various drawbacks, the first being the high production costs which are due to the time needed for the firing of trim pieces. Another drawback comes from the fact that the firing of trim pieces in kilns can cause alterations in the

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tones and/or the geometry which are unacceptable and may also cause cracks and breakages and therefore working scraps.

Disclosure of Invention

5 The aim of the present invention is to overcome the drawbacks described above by means of a production process for special chamfered tiles with which have the features indicated in claim 1 of the following section. The invention is also aimed at a special chamfered tile which is derived from the aforementioned innovative process and has the
10 features indicated in claim 8 of the following section. Finally, the invention is aimed at a trim piece production line as indicated in claim 7.

Further characteristics and advantages of the present invention will better emerge from the detailed description of a preferred embodiment
15 that follows, in the form of a non limiting example, with particular reference to the figure enclosed, in which:

the figure is a perspective view of a special chamfered tile according to the invention.

With particular reference to the figure mentioned, a special tile 1 is produced, preferably by cutting transversally, according to the cutting
20 plan, a basic floor or wall tile 2, as indicated by the arrows T-T.

The special tile 1 therefore also includes a front surface 3 decorated with the same motive as the basic tile 2. At least one of the long edges 5a, 5b of the special tile 1 is chamfered, bevelled or rounded to form the
25 so-called 'bird's beak' 4 which, once the special tiles 1 are laid, remains in view.

The 'bird's beak' 4 is subsequently painted cold with a double component polyurethane paint to obtain a surface finish which is generally similar to or co-ordinated with the finishing and decoration of
30 the front surface 3. In addition to or as an alternative to the aforementioned glaze, the tile can be brought to the correct tone using pigmented primers, for example, those which are solvent based.

The finishing process for the bird's beak profile 4 should preferably include the following phases:

- 35 - a neutral epoxidic primer which acts as a fixative is applied by means of a commonly-known painting apparatus, such as an airbrush, in particular, but not limited to, a manual one;
- the special tile is then left for a pre-determined period, for example 24 hours, at room temperature or in a controlled environment at 20°C
40 for a few hours, preferably two:

- a double component polyurethane painting product, which acts as a decorative surface finish, is then applied by means of a commonly known painting apparatus, such as an airbrush, in particular, but not limited to, a manual one;
- 5 - the special tile is dried for a pre-determined period of time, preferably in a controlled environment at 20°C for approximately two hours;
- the special tile is packed;
- the special tile production line can be at least partially automated and includes, in order:
- 10 - a cutting station for the basic tile;
- a chamfering station for at least one of the special tile's edges;
- a station for the first application of the primer which acts as a fixative, including, for example, an apparatus with a manual airbrush;
- 15 - a rest station with a ventilated compenser where the tile is left at approximately 20°C for approximately two hours;
- a second station, including another apparatus with a manual airbrush, for the application of the surface finish, in particular the double component polyurethane paint;
- 20 - a drying station with a second ventilated compenser where the tile is left at approximately 20°C for approximately two hours;
- a packing station.

25 With the procedure according to the present invention it is possible to reduce production times for basic tiles and co-ordinated special tiles dramatically, with a subsequent reduction in production costs.

Furthermore, the application of a painting product which is generally applied cold, prevents the morphological features, with regards the colour tones and the geometry of the tile's substratum, being altered, in this way guaranteeing a high quality finished product and a dramatic reduction in waste pieces.

30 In some particular cases, depending on the type of substratum of the basic tile, the intended use of the special tile and the features of the glazing product, it is even possible to avoid the primer application phase and the special tile's consequent intermediary resting phase, in this way reducing the production times and costs still further.

Obviously, by maintaining the principle of the present invention, various embodiments are possible and the relevant details can be varied widely with respect to this description and its illustration without falling outside the field of the present invention.

What is claimed

1. A procedure for the manufacture of a special tile from a basic tile which is single fired, porcelain stoneware, double fired, porous single fired or similar, including the following phases:
 - a) the cutting of the basic tile according to a pre-determined cutting plan transversal to a decorated front surface to create a special tile;
 - b) the chamfering, bevelling or rounding of at least one edge of the special tile to form a profile with a pre-determined surface geometry and finish;
 - c) the cold application, to the area of the worked profile, of a painting product which acts as a superficial or decorative finish, by means of a painting apparatus;
 - d) the drying of the special tile for a pre-determined period of time in an environment with a controlled temperature.
2. A procedure as claim 1, wherein the drying phase takes place in a controlled environment at 20°C for a period of approximately two hours.
3. A procedure as in claim 1, wherein the painting apparatus includes an airbrush of a manual type.
4. A procedure as in claim 1, wherein the cold painting product includes a double component polyurethane product.
5. A procedure as in claim 1, wherein after the chamfering phase and before the glazing phase, two further intermediary phases are envisaged:
 - e) the application to the area of the worked profile of a neutral epoxidic pigmented primer which acts as fixative, by means of a painting apparatus.
 - f) leaving the special tile to rest for a pre-determined period of time in a environment with a controlled temperature before the application of the painting product.
6. A procedure as in claim 5, wherein the resting phase takes place in a controlled environment at 20°C for period of approximately two hours.

7. A line for special tiles produced from basic tiles including, in order:
 - a cutting station for the basic tiles;
 - a chamfering, bevelling or rounding station for at least one of the edges of the special tile cut from the basic tile, to form a profile with pre-determined surface geometry and finish;
 - a first station, including an apparatus with a manual airbrush, for the application of a primer which acts as a fixative to the area of the worked profile;
 - a ventilated resting station where the special tile is left at approximately 20°C for approximately two hours;
 - a second station, including an apparatus with a manual airbrush, for the cold application of a painting product for the surface finish to the area of the worked profile;
 - A ventilated drying station where the special tile is left at approximately 20° for approximately two hours;
8. A special tile created from a basic tile, wherein it includes a front surface with a decoration and finish determined in the basic tile manufacturer's plant, and at least one chamfered, bevelled or rounded edge, which defines the worked profile, preferably with a 'bird's beak', cold painted with a painting product to obtain a surface finish which is generally similar to or co-ordinated with the decoration and the finishing of the front surface.

ABSTRACT OF THE DISCLOSURE

A special tile (1) is created from a basic standard tile and includes a front surface (3) with the decoration and finish determined in the basic tile manufacturer's plant. At least one edge (5a, 5b) is chamfered, bevelled or rounded in order to define a worked profile, preferably with a "bird's beak (4)". The worked profile (4) is painted cold with, for example, a double component or solvent based painting product, to obtain a finish which is generally similar to or co-ordinated with the finish and decoration of the front surface. The painting is preferably carried out by means of an apparatus with a manual airbrush, which is preceded by the application of a primer which acts as a fixative. After the application of the primer and the painting product, the special tile (1) is kept in a resting position for a pre-determined period of time in an environment with a controlled temperature or it is brought up to tone using a pigmented primer.

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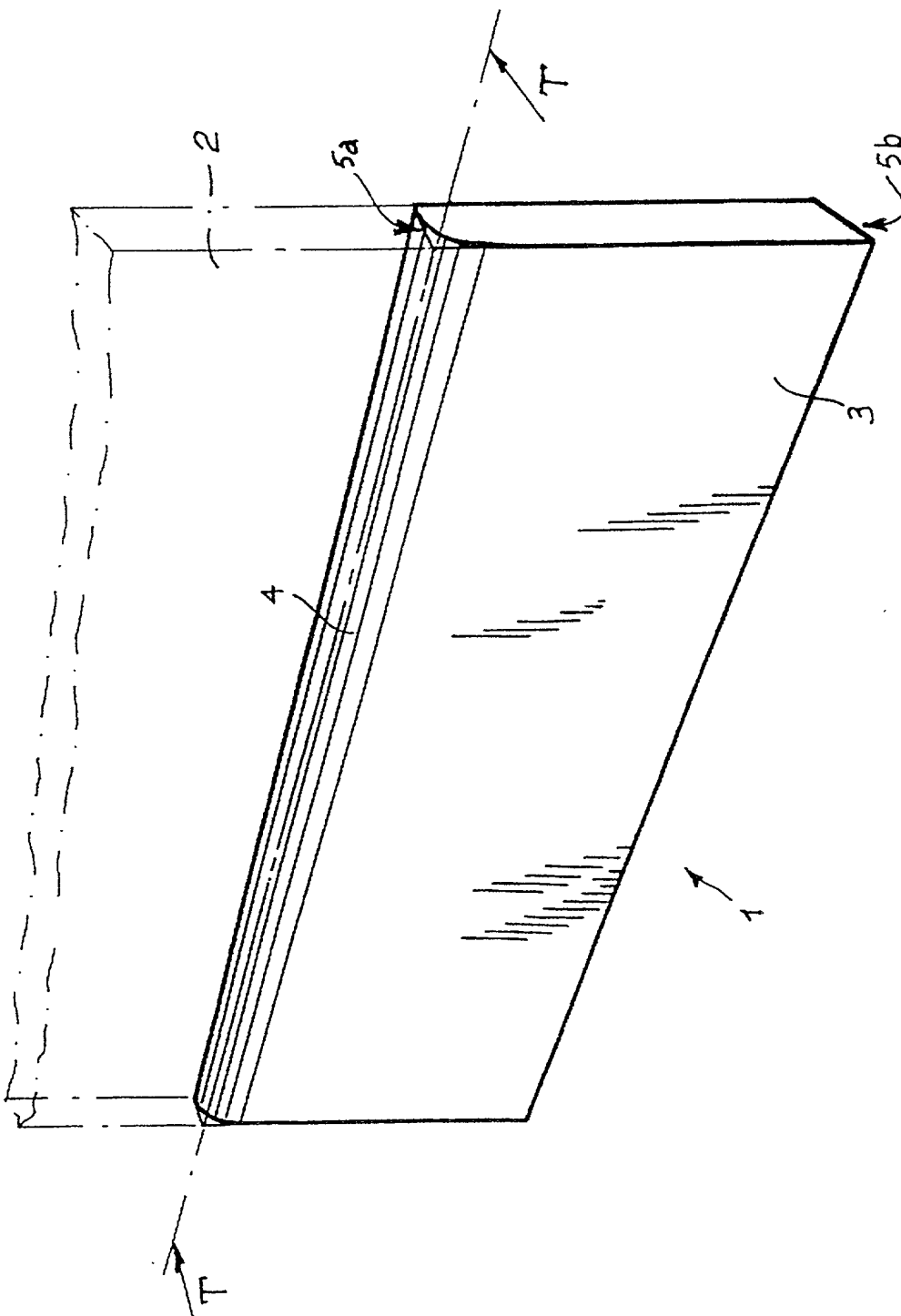


Fig. 1

COMBINED DECLARATION FOR PATENT APPLICATION AND POWER OF ATTORNEY

(Includes Reference to PCT International Applications)

ATTORNEY DOCKET NUMBER

20183

As a below named inventor, I hereby declare that:

My residence, post office address and citizenship are as stated below next to my name,

I believe I am the original, first and sole inventor (if only one name is listed below) or an original, first and joint inventor (if plural names are listed below) of the subject matter which is claimed and for which a patent is sought on the invention entitled

A SPECIAL CHAMFERED TILE AND THE PROCEDURE FOR ITS MANUFACTURE

the specification of which (check only one item below):

☒ is attached hereto.

☐ was filed as United States application

Serial No. _____

on _____

and was amended

on _____ (if applicable)

☒ was filed as PCT international application

Number PCT/EP 99/01649

on March 12, 1999

and was amended under PCT Article 19

on _____ (if applicable)

I hereby state that I have reviewed and understand the contents of the above-identified specification, including the claims, as amended by any amendment referred to above.

I acknowledge the duty to disclose information which is material to the examination of this application in accordance with Title 37, Code of Federal Regulations, §1.56(a).

I hereby authorize the U.S. attorney or agent named herein to accept and follow instructions from GIDIEME
S.R.L. of Modena, Italy

as to any action taken in the Patent and Trademark Office regarding this application without direct communication between the U.S. attorney or agent and the undersigned. In the event of a change in the persons from whom instructions may be taken, the U.S. attorney or agent named herein will be so notified by the undersigned.

I hereby claim foreign priority benefits under Title 35, United States Code, §119 of any foreign application(s) for patent or inventor's certificate or of any PCT international application(s) designating at least one country other than the United States of America listed below and have also identified below any foreign application(s) for patent or inventor's certificate or any PCT international application(s) designating at least one country other than the United States of America filed by me on the same subject matter having a filing date before that of the application(s) of which priority is claimed:

PRIOR FOREIGN/PCT APPLICATION(S) AND ANY PRIORITY CLAIMS UNDER 35 U.S.C. 119

COUNTRY (if PCT, indicate "PCT")	APPLICATION NUMBER	DATE OF FILING (day, month, year)	PRIORITY CLAIMED UNDER 35 USC 119	
Italy	MO98A000064	24/03/98	<input checked="" type="checkbox"/> YES	<input type="checkbox"/> NO
PCT	PCT/EP 99/01649	12/03/99	<input checked="" type="checkbox"/> YES	<input type="checkbox"/> NO
			<input type="checkbox"/> YES	<input type="checkbox"/> NO
			<input type="checkbox"/> YES	<input type="checkbox"/> NO
			<input type="checkbox"/> YES	<input type="checkbox"/> NO

Combined Declaration For Patent Application and Power of Attorney (Continued)

(Includes Reference to PCT International Applications)

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I hereby claim the benefit under Title 35, United States Code, §120 of any United States application(s) or PCT international application(s) designating the United States of America that is/are listed below and, insofar as the subject matter of each of the claims of this application is not disclosed in that/those prior application(s) in the manner provided by the first paragraph of Title 35, United States Code, §112, I acknowledge the duty to disclose material information as defined in Title 37, Code of Federal Regulations, §1.56(a) which occurred between the filing date of the prior application(s) and the national or PCT international filing date of this application:

PRIOR U.S. APPLICATIONS OR PCT INTERNATIONAL APPLICATIONS DESIGNATING THE U.S. BENEFIT UNDER 35 U.S.C. 120

U.S. APPLICATIONS

STATUS (Check one)

U.S. APPLICATION NUMBER

U.S. FILING DATE

PATENTED

PENDING

ABANDONED

PCT APPLICATIONS DESIGNATING THE U.S.

PCT APPLICATION NUMBER

PCT FILING DATE

U.S. SERIAL NUMBERS
ASSIGNED (if any)

PCT/EP 99/01649

12/03/99

POWER OF ATTORNEY: As a named inventor, I hereby appoint the following attorney(s) and/or agent(s) to prosecute this application and transact all business in the Patent and Trademark Office connected therewith. (List name and registration number)

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	RESIDENCE & CITIZENSHIP	CITY	STATE OR FOREIGN COUNTRY	COUNTRY OF CITIZENSHIP
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203	FULL NAME OF INVENTOR	FAMILY NAME	FIRST GIVEN NAME	SECOND GIVEN NAME
	RESIDENCE & CITIZENSHIP	CITY	STATE OR FOREIGN COUNTRY	COUNTRY OF CITIZENSHIP
	POST OFFICE ADDRESS	POST OFFICE ADDRESS	CITY	STATE & ZIP CODE/COUNTRY

I hereby declare under penalty of perjury under the laws of the United States of America that all statements made herein of my own knowledge are true and that all statements made on information and belief are believed to be true; and further that these statements were made with the knowledge that willful false statements and the like so made are punishable by fine and imprisonment, or both, under section 1001 of Title 18 of the United States Code, and that such willful false statements may jeopardize the validity of the application or any patent issuing thereon.

SIGNATURE OF INVENTOR 201

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DATE

9/14/2000

DATE

DATE